

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005462**Date Inspected:** 05-Feb-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** As listed below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** TOWER COMPONENTS**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Luis Hutchins, was present during the times noted above for observations relative to the work being performed.

Inprogress welding:

FCAW welding of welds joint NSD1-SA17 F/G- 91 and 101. Welder are identified as 067037 and 066165. ZPMC QC is identified as Chen Likun. The welding variables recorded by QC appeared to comply with the WPS #B-T-2331-TC-P4-T-2.

FCAW welding of welds joint NSD1-SA223 E/E- 1, 6, and 8. Welders are identified as 057186 and 057220. ZPMC QC is identified as Chen Shou Hua. The welding variables recorded by QC appeared to comply with the WPS #B-T-2231-TC-U5-F.

FCAW welding of welds joint NSD1-SA225 F/H- buttering of the ends of the stiffeners to skin plate. Welders are identified as 068917, 049220, and 053316. ZPMC QC is identified as An Qing Xiang. The welding variables recorded by QC appeared to comply with the WPS #345-FCAW-3G(3F)-REPAIR.

SMAW welding of welds joint WSD1-SA294 A/G- 2, 3, 6, and 9. Welder identified as 040614 and 049099. ZPMC QC is identified as Xu Le Feng. The welding variables recorded by QC appeared to comply with the WPS #345-SMAW-2G(2F)-Repair.

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Ultrasound Inspection:

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a UT report for this date. The members are identified in that report.

Magnetic Particle Inspection:

This QA inspector performed MT of approximately 25% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a MT report for this date. The members are identified in that report.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No significant conversations held during the course of inspection.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Hutchins,Luis	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
